

Work Order ID 153499

Monday, November 21, 2016 9:23:39 AM

153499

Page 1

Item ID: D4780-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Cover Mounting Bracket Assembly
Start Date: 11/14/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 11/21/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS Date: NOV 21 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4780	A								
100	FLOW WATER JET	0.01							
100									
Waterjet	Memo	0.02							
FLOW CNC Waterjet	1-Cut D4780-1 as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

NOV 30 2016
DAS
38
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																	
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Page 2

Item ID: D4780-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Cover Mounting Bracket Assembly

Start Date: 11/14/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 11/21/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.02 0.01			DAS 30 9-89	②			DEC 08 2016
140 *140* Small Fab Small Fab	 Memo 1- C'sink holes as per dwg	0.00 0.01				2x			DAS 36 9-89 16/12/07
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				2			DAS 38 9-89 DEC 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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NS1

NS?

Reference:

NR1

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.02				(x2)	0		2016/12/15
Hand Finishing									B
165	QC7-Inspect Chemical Conversion Coat	0.00							
165									
QC	Memo	0.00				2	0	16-12-15	DAS 34 9-89
Quality Control									
170	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:05 OVEN TEMPERATURE: 300 FINISH TIME: 11:25					2	0	16-12-15	DAS 34 1-89

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

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Page 4

Item ID: D4780-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Cover Mounting Bracket Assembly
Start Date: 11/14/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 11/21/2016 Req'd Qty: 2.00 ***2*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>2</u>			DAS 38 9-89 DEC 15 2016
190 *190* Small Fab Small Fab	Memo 1- Install nutplate as per dwg	0.00 0.01				<u>2</u>	<u>FF</u>		DEC 16 2016
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>2</u>			DAS 38 9-89 DEC 16 2016

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <i>ST 125</i>	0.00				<i>2x</i>		DEC 19 2016	<i>DAS</i> 26 <i>9-89</i>
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							<i>DAS</i> 21 <i>9-89</i>
220								DEC 19 2016	
QC	Memo	0.03							
Quality Control									

(Signature) DEC 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coor. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																					

Picklist Print

Monday, November 21, 2016 9:23:39 AM

Page 1

Work Order ID: 153499

153499

Parent Item: D4780-041

D4780-041

Parent Item Name: Fwd Cover Mounting Bracket Assembly

Start Date: 11/14/2016

Required Date: 11/21/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	152.1975	0.0722	0.152			

M6061T6S 032

6061-T6 Sheet 0.032"

21/11/29

Location

Loc Qty

Loc Code

MAT021 *132772*

152.197476

.2

m131352

46.74

m133757

13.857476

m135724

91.6

MS20426AD3-4

Purchased

No

Each

4,271.000

8

MS20426AD3-4

FF

DEC 16 2016

RIVET

NOT Pulled needs to be changed to 3-3 ASS 2016.12.19

Location

Loc Qty

Loc Code

ST312

135274

4271

8

m134294

4271

8

MS21059L3

Purchased

No

Each

156.0000

4

MS21059L3

FF

DEC 16 2016

Nut Plate

Location

Loc Qty

Loc Code

GA

29

M135603

29

4

ST301

127

M135704

2

M135774

60

M136047

65

DQA: _____ Date: _____



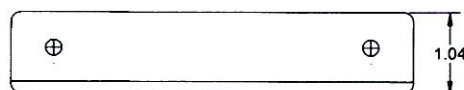
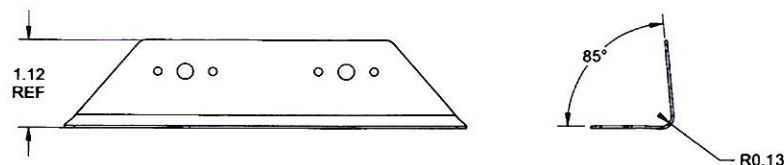
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OTHER : _____																									

QTY -041	P/N	DESCRIPTION
X	D4780-041	FWD COVER MOUNTING BRACKET ASSY
1	D4780-1	FWD COVER MOUNTING BRACKET
4	MS20426AD3-4	RIVET, CSK
2	MS21059L3	NUTPLATE



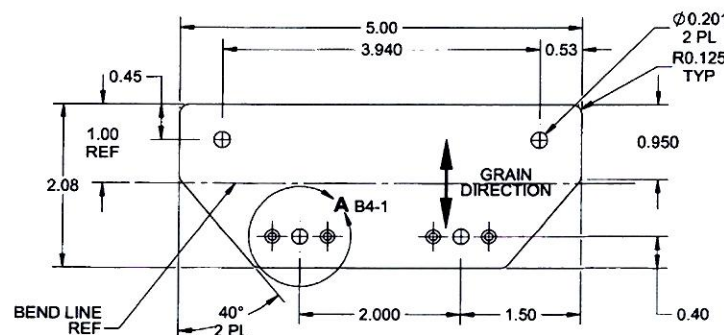
D4780-1 FWD COVER MOUNTING BRACKET
(MAKE FROM D4780-1F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153499 MJS
16-11-21

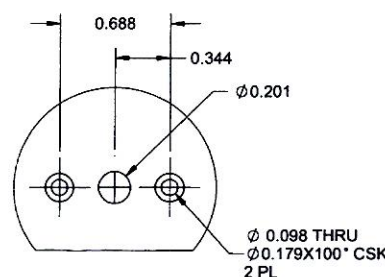
D4780-1 FWD
COVER MOUNTING BRACKET

MS20426AD3-4 RIVET
2X, 2PL

MS21059L3
NUTPLATE
2 PL



D4780-1F FLAT PATTERN



DETAIL A B7-1
SCALE 2X
2 PL

D4780-041 FWD COVER MOUNTING BRACKET ASSY

RELEASED
H 2013-03-11

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032" THICK, PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF. DART SPEC. M6061T6S.032)
- 2) FINISH: D4780-1F: NONE, D4780-1: CHEMICAL CONVERSION COATING PER DART QSI 005 4.1, POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3, D4780-041: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4780-041" AND B/N USING FINE POINT PERMANENT INK MARKER PER DART QSI 044 METHOD 6.1
- 7) WEIGHT: 0.02 lbs
- 8) PROFILE PER DRAWING FILE "D4780-1F-REVA.DXF"

A	NEW RELEASE	DB	13.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AR	DRAWING NO.	REV. A
MFG. APPR.		D4780	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		FWD COVER MOUNTING BRACKET ASSY	NTS
DATE	13.03.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	